

Date: Wednesday, 11/10/2006 10:40:40 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SHUT-OFF VALVE SHAFT
<b>Job Number</b>	: 28871		
<b>Estimate Number</b>	: 12187		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D34695
<b>This Issue</b>	: 11/10/2006	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3469 REV.A1
<b>First Issue</b>	: 04/10/2006	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 27013	<b>Drawing Revision</b>	: A1
	<b>Type</b> : PURCHASED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 11/10/2006
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	4 <b>Um:</b> Each
<b>Comment</b>	: est rev A 06.02.06 new issue EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.2857 sf(s)/Unit Total: 1.1428 sf(s)  
 304/316 0.018 SHEET  
 (M304S26GA)  
 Batch: m19704 ml 06 10 13

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 Cut as per Dwg D3469  
 Dwg Rev: A1  
 Prog Rev: A1

ml 06 10 13 (1)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 10 13 (2)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

06-10-13

5.0	NAS1031C3W	Nutplate
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**Comment:** Qty.: 17.0000 Each(s)/Unit Total: 68.0000 Each(s)  
 pick:

Qty	Part number	Description	Batch
17	NAS1031C3W	Nutplate	<u>m101144</u>

mf 06/10/13 (17)

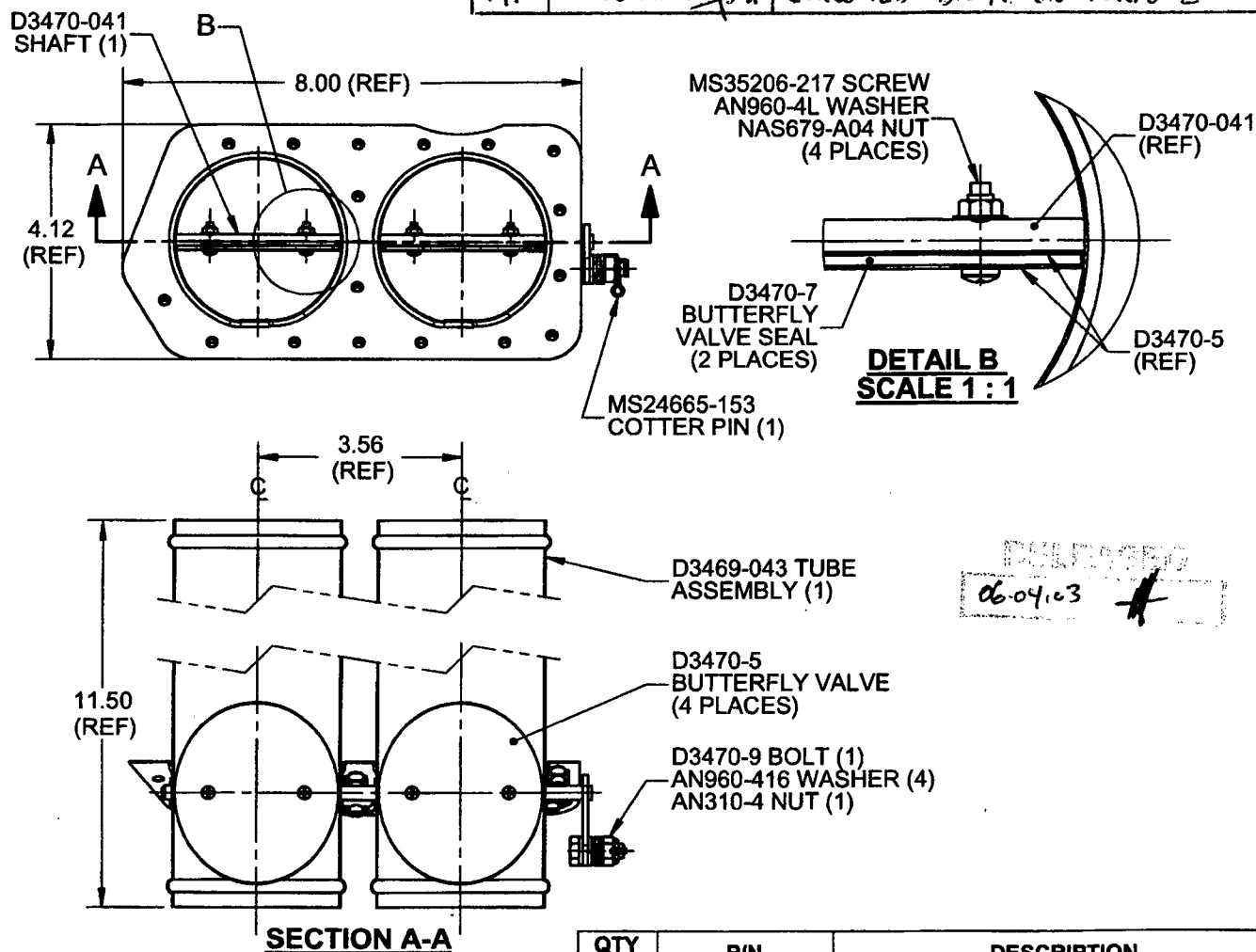
Date: Wednesday, 11/10/2006 10:40:40 AM  
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## Process Sheet

<b>Customer:</b> CU-DAR001 Dart Helicopters Services		<b>Drawing Name:</b> SHUT-OFF VALVE SHAFT	
<b>Job Number:</b> 28871		<b>Part Number:</b> D34695	
Job Number:			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1			
1-Deburr if necessary		MF - 06/10/13	
2-form oval flanges per dwg D3469 using DT8850			
3-Spot weld nut plates as per dwg D3469		MF - 06/10/13	
7.0	QC5/9	WELD INSPECTION	
			
<b>Comment:</b> WELD INSPECTION		SB 06/10/13	
8.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
<b>Comment:</b> PACKAGING RESOURCE #1			
Identify and Stock			
Location: GA		SB 06/10/13	
9.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
<b>Comment:</b> FINAL INSPECTION/W/O RELEASE			
Job Completion			
		4 06-10-12	



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.2013	CORRECTED B.O.M. ON PAGE 2	



### D3469-041 SHUT-OFF VALVE ASS'Y

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

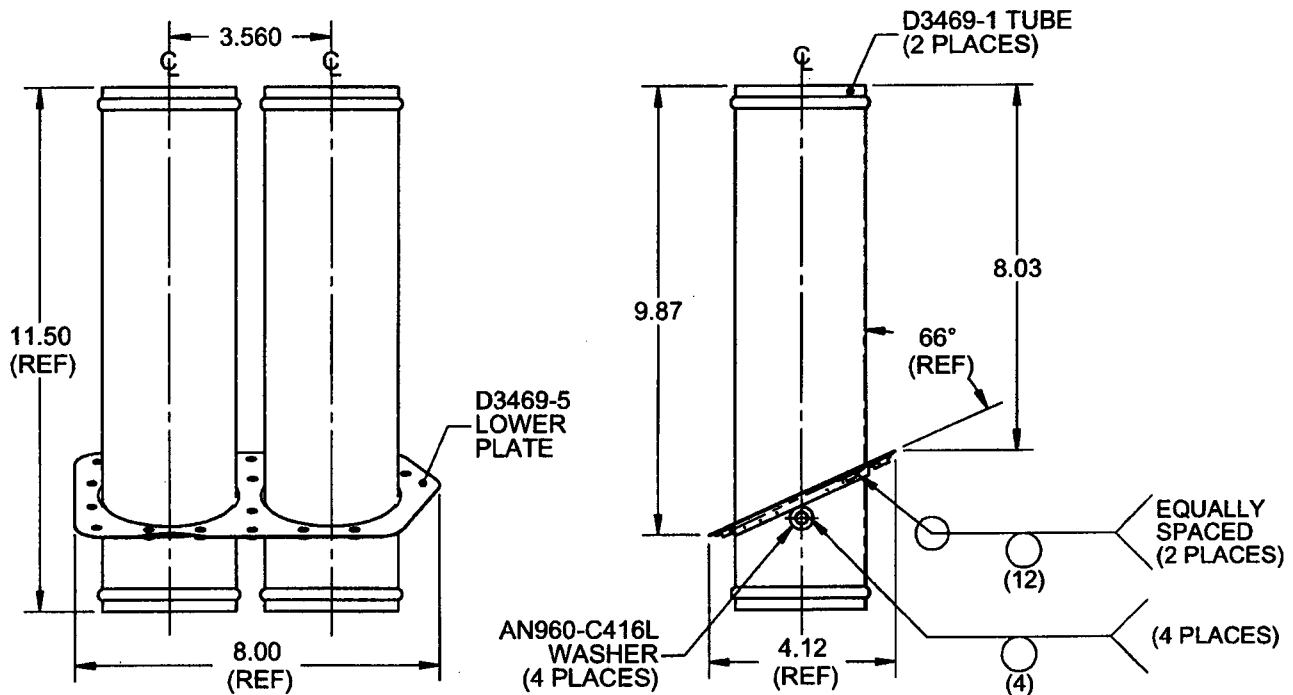
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CHECKED #	APPROVED #	DRAWING NO. D3469	REV. A SHEET 2 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4


REVISIONS  
# 06.04.03



### D3469-043 TUBE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

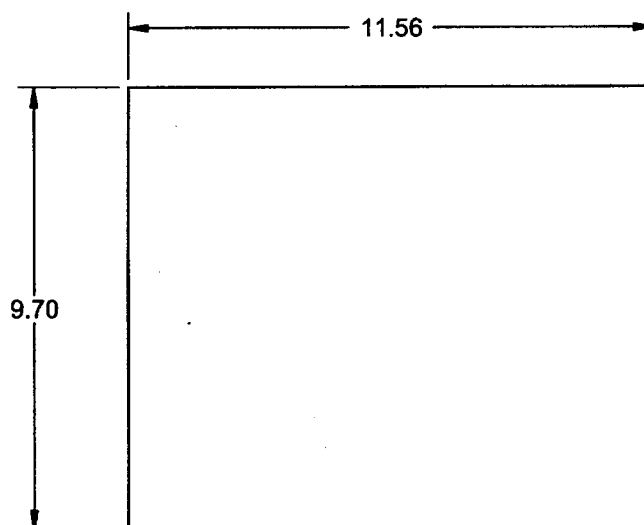
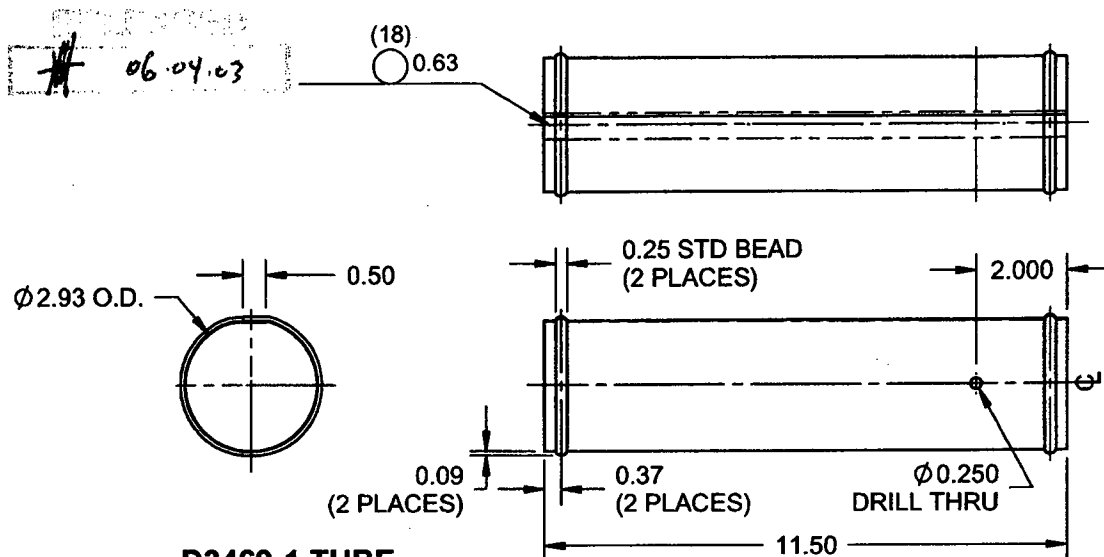
QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	<del>D3470-5</del>	<del>PLATE VALVE</del> 
4	AN960-C416L	WASHER

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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4



### D3469-1F TUBE FLAT PATTERN

#### NOTES:

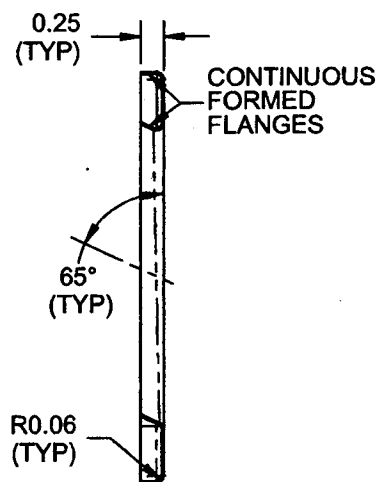
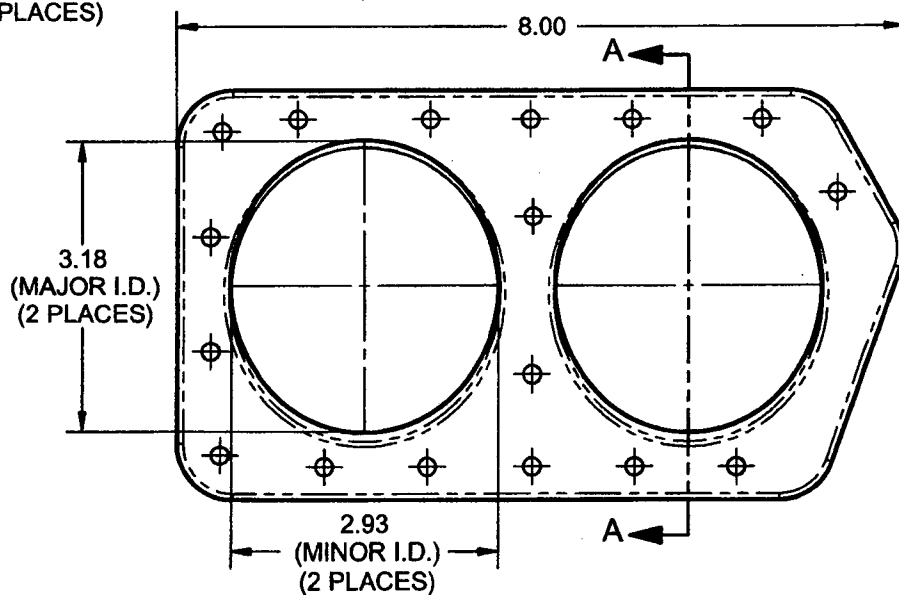
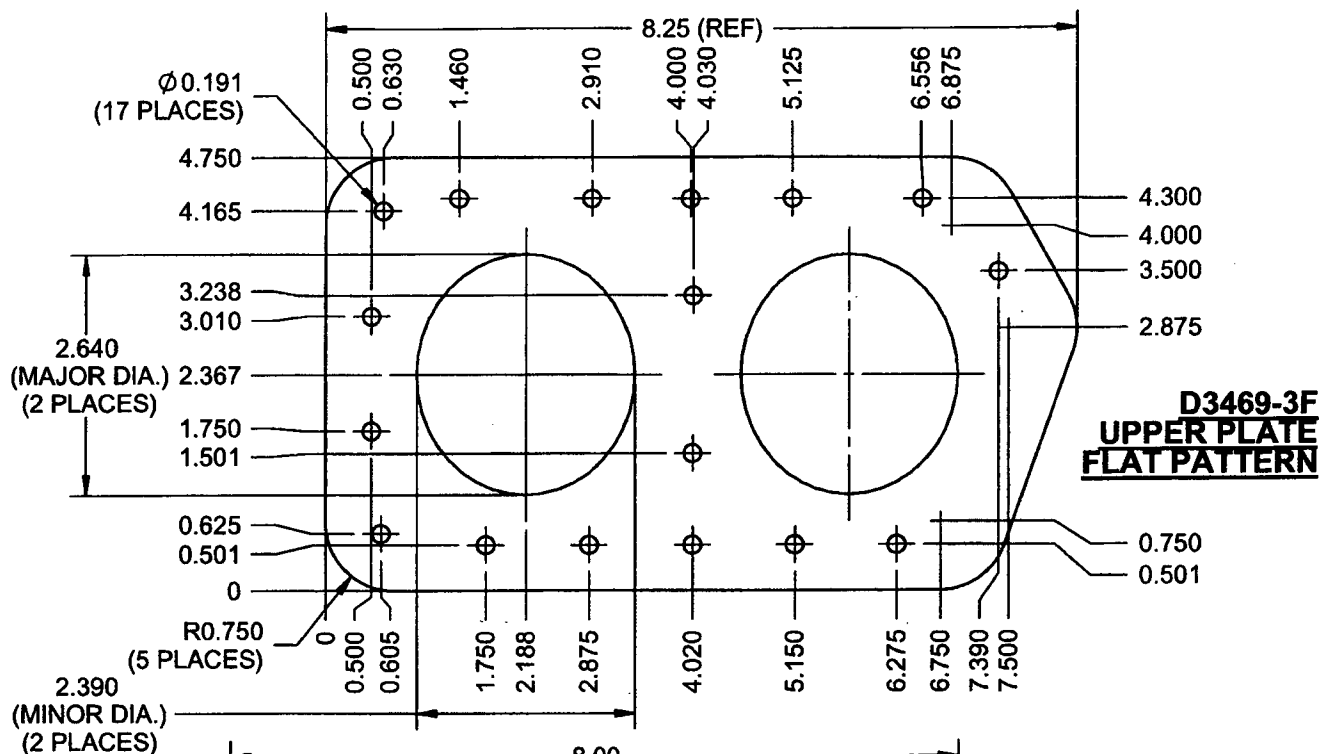
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



### D3469-3 UPPER PLATE BENDING DETAIL

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

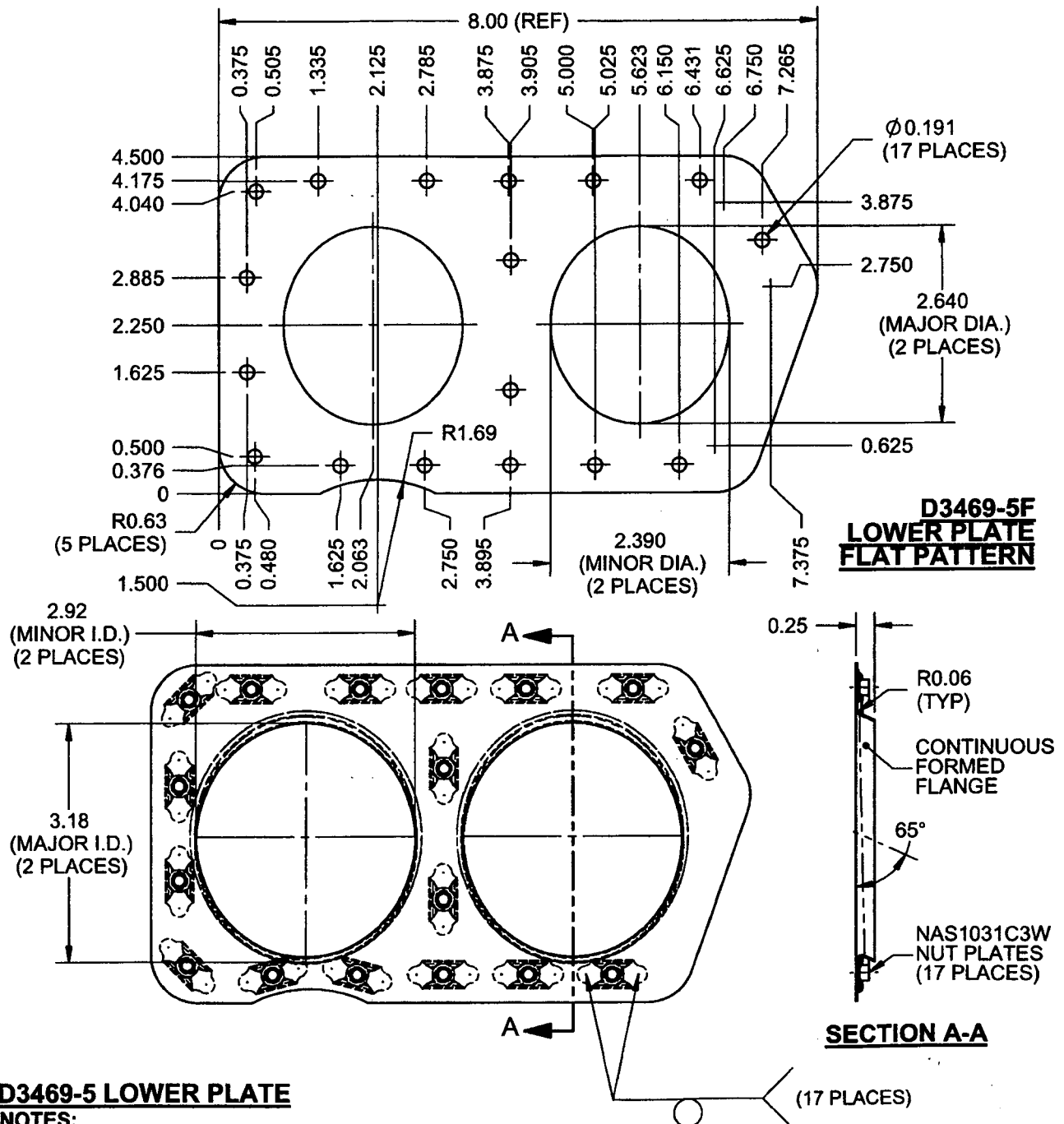
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3469</b>	REV. A SHEET 5 OF 5
DATE <b>05.12.12</b>		TITLE <b>SHUT-OFF VALVE ASS'Y</b>	SCALE 1:2



**D3469-5 LOWER PLATE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Page 1 of 1



NO. 34

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Melanie Fauteux  
Joint Welding Procedure Spot Welding  
Part number and Job number B3469-503 B 2887

TEST WELDS REQUIRED

BASE METAL 304 2CC WELDING PROCESS Spot  
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐  
Current AC ☐ DC ☒ Backing YES ☐ NO ☒ Win

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

N/A

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/13 Qualifier Sylvie Bocher

# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 34 *Replaces*

EMPLOYEE: Melanie ~~Fau~~ Fautoux

PART NUMBER: D3469-5

JOB NUMBER: B28871

MATERIAL TYPE: 304 SS

MATERIAL THICKNESS: .018

GROUP SPECIFICATION: 2

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <u>X</u> ]	[     ]
PENETRATION:	[ <u>X</u> ]	[     ]
PULL STRENGTH:	[ <u>X</u> ]	[     ]

PSI Reading: Not Available

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 06.10.13

QUALIFIER: *[Signature]* 06.10.13